



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D6104-005
Job Sheet 170398



~~5037824~~
5037868

Part No: D6104-005

Job Qty: 10 ea ✓

Part Name: Round Billet, 17-4



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/16/18

Job Tracking No:

Due Date: 2/6/18

Created By: Diane Baker

Type: Stock

Description:

Note: DWG REV B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	10 pcs	2/6/18	2/6/18	0.00	0.00	Purchasing		DAS 11
110	Packaging	10 pcs	2/6/18	2/6/18	0.00	0.00	Packaging2		DAS 89 11
120	QC	10 pcs	2/6/18	2/6/18	0.00	0.00	QC18		11 9-89
130	Packaging	10 pcs	2/6/18	2/6/18	0.00	0.00	Packaging3-2		9-89 18-02-02
140	QC21-SA	10 Ea	2/6/18	2/6/18	0.00	0.00	QC21		MLS FEB 05 2018

Part Op 100 - Issue P/O: 38795 b) Ø4.00" x 5.10" long d) Material: 17-4PH Stainless steel (Ams 5643 or Aisi 630)

Descriptions: 110 - Ensure material certification is attached

120 - Ensure Material certification comply to Dwg D6104

130 - LOCATION: MAT043

JAN 16 2017

WLB

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
100-Purchasing	D6104-005P	10	0	0	0

Part Specifications

Specifications could not be found.

Plex 1/16/18 9:16 AM dart.baker.diane

JAN 31
JAN 31
JAN 31
FEB 05 2018

DART
AEROSPACE
S037868

Dart Aerospace Ltd.

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Round Billet, 17-4

PART NO: D6104-005

Original Serial #: S037868

Revision:

Operation: QC

Change No:

Mfg Date: 02/01/18

Job No: 170398

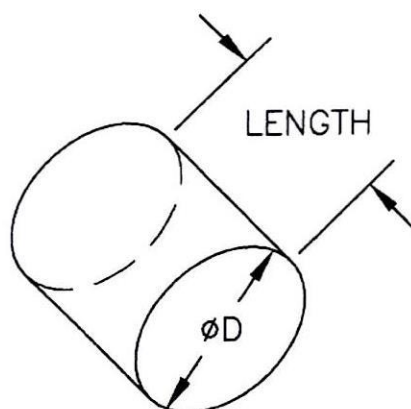
DART

DESIGN 17	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D6104	Rev. B SHEET 1 OF 1
DATE 02.11.25		TITLE ROUND BILLET, 17-4	SCALE NTS
A	01.04.10	NEW ISSUE	
B	02.11.25	CLARIFY ALLOY SPEC ADDED D6104-009/-011 REDUCE LENGTH OF BILLETS	

RELEASED

02.11.29

SPECIFICATION CONTROL DRAWING



MATERIAL: 17-4 PH SS (AMS 5643 OR AISI 630) MIN UTS = 170 KSI (38 HRC)

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES

Part No.	Alloy	D (Diameter)	Length
D6104-001	17-4 PH STAINLESS STEEL	Ø3.00	3.80
D6104-003	17-4 PH STAINLESS STEEL	Ø3.25	3.80
D6104-005	17-4 PH STAINLESS STEEL	Ø4.00	5.10
D6104-007	17-4 PH STAINLESS STEEL	Ø4.50	5.10
D6104-009	17-4 PH STAINLESS STEEL	Ø5.25	4.10
D6104-011	17-4 PH STAINLESS STEEL	Ø6.50	4.10

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